

DART AEROSPACE LTD	Work Order:	24093
Description: Hi - Step Leg Assembly	Part Number:	D3065-041
Dwg: D3065 Rev. A1 A2 RF 05.04.17 RF 03.02.28	Qty:	60
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller Dwg. not required RF 02.11.04 (Minimum lots of 30)	JL	05.08.23	60
2	MV	Cut blanks: 3.600" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick M17948 (M2024T3S.040) Identify as D3065-1 4.320" RF 02.11.29 4.320"	J.L.	05.09.27	60
3	MV	Cut blanks: 6.600" x 4.250" (grain along 4.320") 4.250" RF Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick M17948 (M2024T3S.040) Identify as D3065-3	J.L.	05.09.28	60
4	MV	Cut blanks: 4.580" x 4.500" (grain along 4.500") Material: 2024-T3 Sheet (QQ-A-250/4) 0.040" thick (M2024T3S.040) Identify as D3065-7	J.L.	05.09.27	60
5	MV	Cut blanks: 16.61" x 8.51" (grain along 8.51") for each leg. Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Identify as D3065-5 (Note: make 2 legs per assembly)	JL	05.09.30	120
6	MV	Cut blanks: 16.490" x 0.750" for each spacer. (-0.00/+0.010) Material: 5052-H32 Sheet (QQ-A-250/8) 0.080" thick (M5052H32S.080) Identify as D3066-1 (Note: make 2 spacers per assembly)	JL	05/10/05	120
7	MV	Machine D3065-1 as per folio FA182 and Dwg D3065, use stack of 15.	J.L.	05.10.02	60
8	MV	Deburr to take measurement	J.L.	05.10.02	60
9	QC2	Inspect parts as they come off the CNC machine	J.L.	05.10.02	60
10	QC8	Second check	JL	05/10/02	60
11	MV	Machine D3065-3 as per folio FA180 and Dwg D3065, use stack of 15.	J.L.	05.10.02	60
12	MV	Deburr to take measurement	J.L.	05.10.02	60
13	QC2	Inspect parts as they come off the CNC machine	J.L.	05.10.02	60
14	QC8	Second check	JL	05/10/02	60
15	MV	Machine D3065-7 as per folio FA181 and Dwg D3065, use stack of 15.	J.L.	05.10.02	60
16	MV	Deburr to take measurement	J.L.	05.10.02	60
17	QC2	Inspect parts as they come off the CNC machine	J.L.	05.10.02	60
18	QC8	Second check	JL	05/10/02	60
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	/	/	/

RELEASED
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	24093
Description: Hi - Step Leg Assembly RF 03.02.28	Part Number:	D3065-041
Dwg: D3065 Rev. A1 A2 RF 03.02.28	Qty:	60
		Page 2 of 2

Step	Location	Procedure	By	Date	Qty																								
19	MV	Machine D3065-5 as per folio FA179 and Dwg D3065, use stack of 10.	JL	05/10/04	120																								
20	MV	Déburr to take measurement	JL	05/10/04	ND																								
21	QC2	Inspect parts as they come off the CNC machine	JL	05/10/04	120																								
22	QC8	Second check	SD	05.10.05	120																								
23	MV	Machine D3066-1 as per Folio FA280 and Dwg D3066, use stack of 10.	JL	05/10/05	120																								
24	MV	Deburr to take measurement	JL	05/10/05	120																								
25	QC2	Inspect parts as they come off the CNC machine	JL	05/10/05	120																								
26	QC8	Second check	SD	05/10/06	120																								
27	GA	Deburr D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1 stack.	SAD	05/10/16	120																								
28	GB	Bend D3065-1, D3065-3 & D3065-7 as per Dwg D3065 <i>60 60 60</i>	SB	05/10/26	60																								
29	QC5	Inspect work to Step 28	JL	05.10.27	60																								
30	FP	Chemical conversion coat as per QSI 005 4.1 RF 02.11.06 D3065-1, D3065-3, D3065-5, D3065-7 & D3066-1	DL	05/10/27	60																								
31	GA	Assemble as per Dwg D3065 and identify as D3065-041 Assembly. <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3065-1</td> <td>Spacer</td> <td>B 24093</td> </tr> <tr> <td>1</td> <td>D3065-3 22854</td> <td>Spacer</td> <td>B 24093</td> </tr> <tr> <td>2</td> <td>D3065-5 22860</td> <td>Leg 1/2 B 23618 18 B 24093</td> <td>SB 05/11/08 10</td> </tr> <tr> <td>1</td> <td>D3065-7</td> <td>Spacer</td> <td>B 24093</td> </tr> <tr> <td>30</td> <td>MS20470AD4-4</td> <td>Rivet (40) n 17405 1760 M17944</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3065-1	Spacer	B 24093	1	D3065-3 22854	Spacer	B 24093	2	D3065-5 22860	Leg 1/2 B 23618 18 B 24093	SB 05/11/08 10	1	D3065-7	Spacer	B 24093	30	MS20470AD4-4	Rivet (40) n 17405 1760 M17944				
Qty	Part Number	Description	Batch																										
1	D3065-1	Spacer	B 24093																										
1	D3065-3 22854	Spacer	B 24093																										
2	D3065-5 22860	Leg 1/2 B 23618 18 B 24093	SB 05/11/08 10																										
1	D3065-7	Spacer	B 24093																										
30	MS20470AD4-4	Rivet (40) n 17405 1760 M17944																											
32	QC5	Inspect work to Step 31	JL	05.11.10	10																								
33	GA	Identify and Stock D3065-041 Hi-Step Leg Assembly 339 D3066-1 Spacer Location 338	JL	05/11/00	120																								
34	AC	Cost / part 39.86	SM	05/11/15	60																								
35	DC	Close W/O 90.56 Inspect Level 21	Q	05/11/16	160																								

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	SM	
B	02.09.10	Re-format; Incorporated D3065-1/-3/-5/-7	KJ	
C	02.11.01	Incorporated D3066-1 IPP	KJ RF	

RELEASED
02/11/04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/11/08	31	2 parts D3065-5 was scrap scratch To deep 1 parts D3065-3 was scrap	MB 05/11/08	Scrap - 5 ! DESTROY	05-11-08	05-11-08	MB 05/11/08	05-11-08

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA:



Date: 05/11/16

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

D3065-5DART AEROSPACE LTD	Work Order:	24093
Description: Step Spacer	Part Number:	D3065-1
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J-L	Audited by:	EP	Prototype Approval:	N/A
Date:	05.10.01	Date:	05.10.02	Date:	03.10.08

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/o D.3065-041	KJ/RF

RELEASED
03.10.08 RFB

D3065-5DART AEROSPACE LTD	Work Order:	24093
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L.	Audited by:	JNL	Prototype Approval:	N/A
Date:	05-10-02	Date:	05/10/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	

RELEASED
July 04, 2012

D3065-5DART AEROSPACE LTD	Work Order:	24093
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L	Audited by:	<i>JML</i>	Prototype Approval:	N/A
Date:	05/10/03	Date:	<i>05/10/03</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	

RELEASED

H:\FORMS\Quality Assurance\approved QA\FAI revD

D3065-5DART AEROSPACE LTD	Work Order:	24093
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065 Rev: A2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.L	Audited by:	E.P.	Prototype Approval:	N/A
Date:	05/10/02	Date:	05/10/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	

RELEASED

Jeffrey · 06 · 27 ·

D3065-5DART AEROSPACE LTD	Work Order:	24093
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>JF</i>	Audited by:	<i>SP</i>	Prototype Approval:	<i>N/A</i>
Date:	05/10/05	Date:	05/10/06	Date:	03.10.08

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/o D3065-041	KJ/RF	AT

RELEASED
03.10.08

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 18, 2005
10:59 am

Work Order No : 0024093
 Project Name : D3065-041
 Project For : WK540
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3065-041
 Description : Step Leg Assembly
 Manufactured : Yes
 Amount Req'd : 60
 Amount Done : 0
 Start Date : 08-17-05
 Est Finish Date :
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

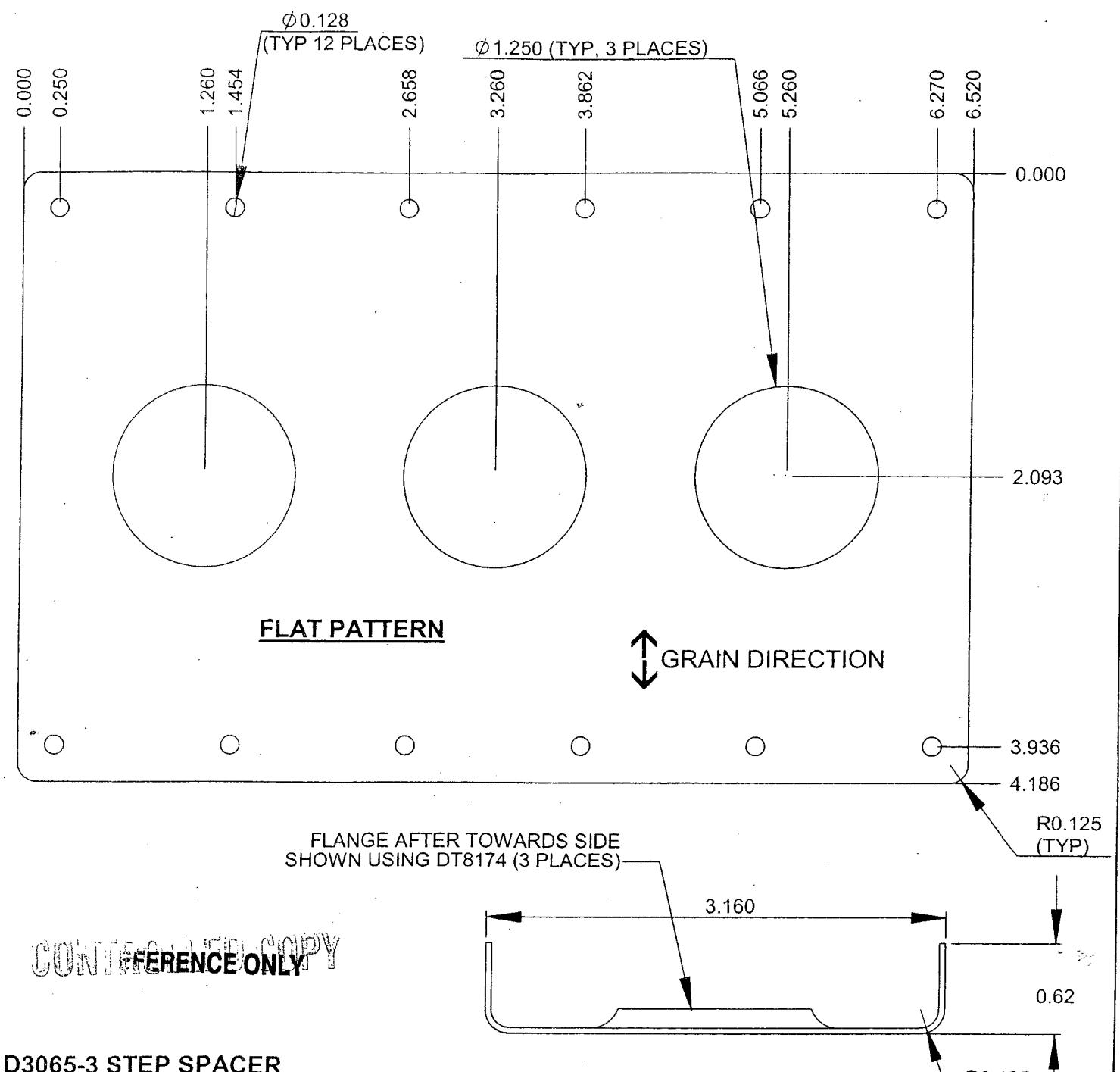
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

02.09.20

COPY IS
OFFICE

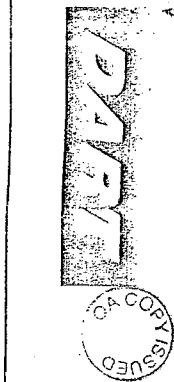
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3065
DATE	02.09.11	TITLE STEP LEG ASSEMBLY

REV. A
SHEET 3 OF 5
SCALE
1:1

**D3065-3 STEP SPACER**

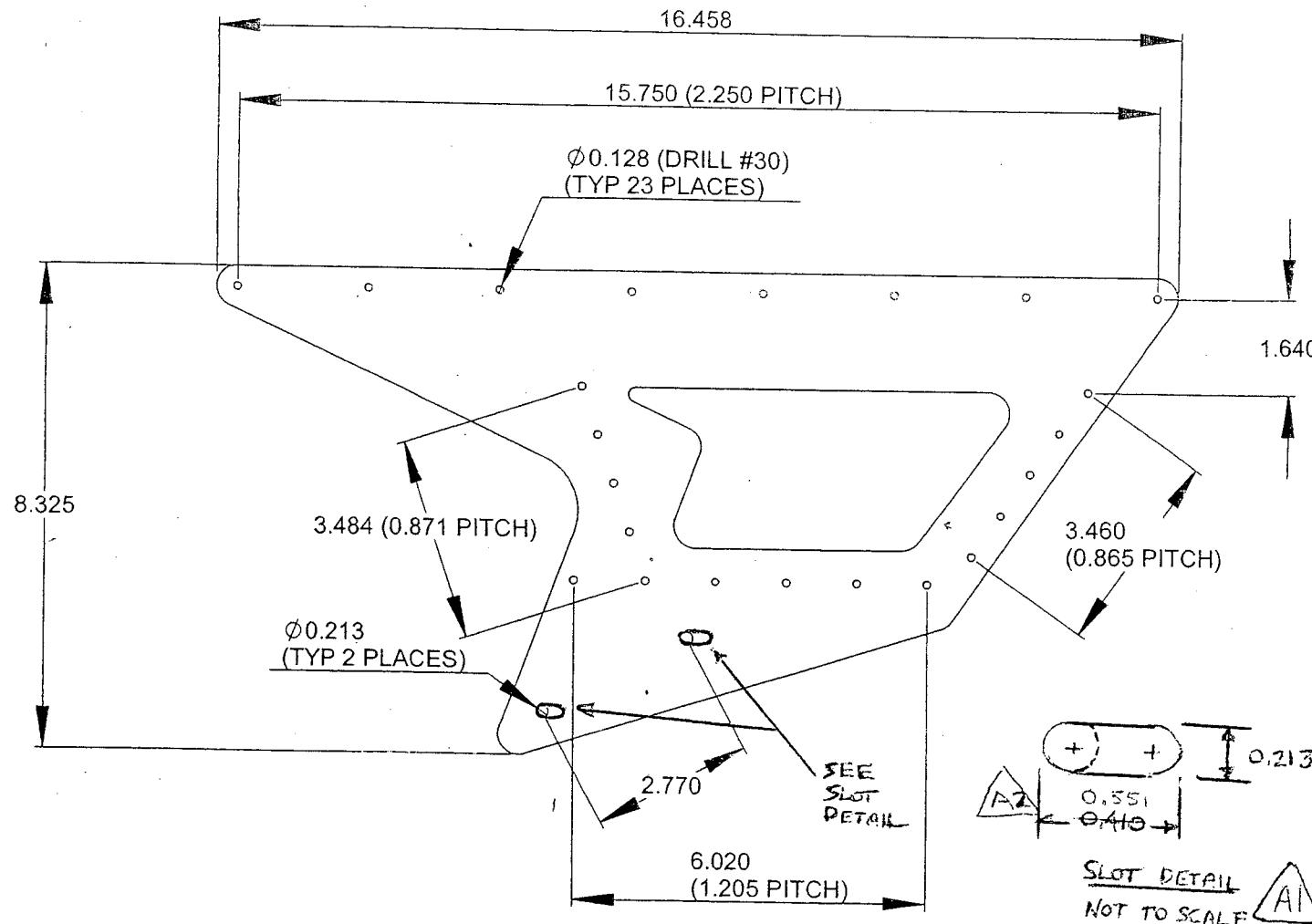
- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BEND DETAIL



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
		D3065	REV. A
DATE	02.09.11	TITLE	STEP LEG ASSEMBLY
		SHEET 4 OF 5	
		SCALE	1:3

PRINTED COPY REFERENCE ONLY



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

CONTOLLED copy

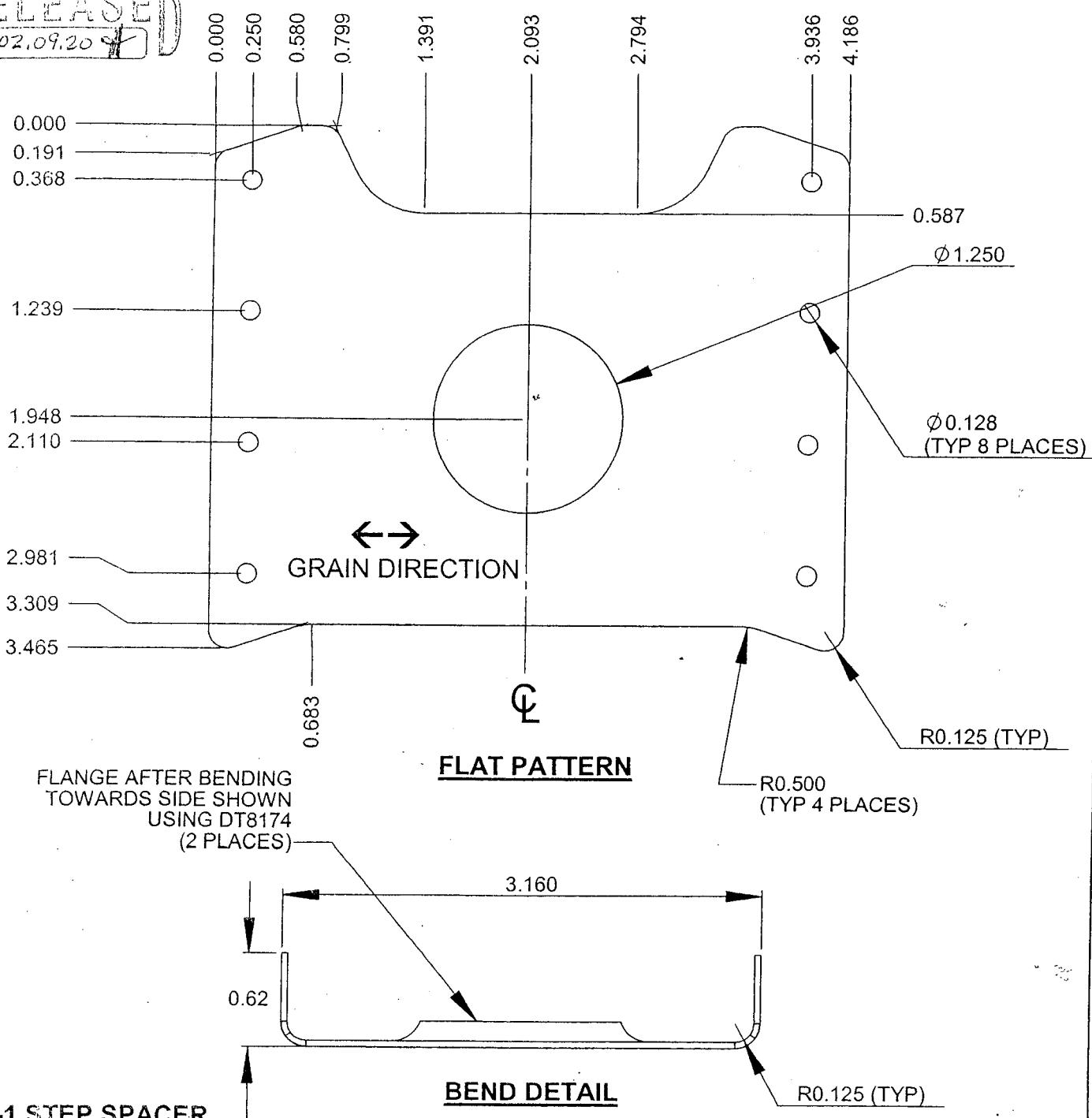


REFERENCE ONLY



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>HT</i>	APPROVED <i>HT</i>	DRAWING NO. D3065	REV. A	SHEET 2 OF 5
DATE 02.09.11	TITLE STEP LEG ASSEMBLY	SCALE 1:1		

RELEASED
02.09.20



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
 - 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
 - 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 4) PART IS SYMMETRIC ABOUT CENTERLINE
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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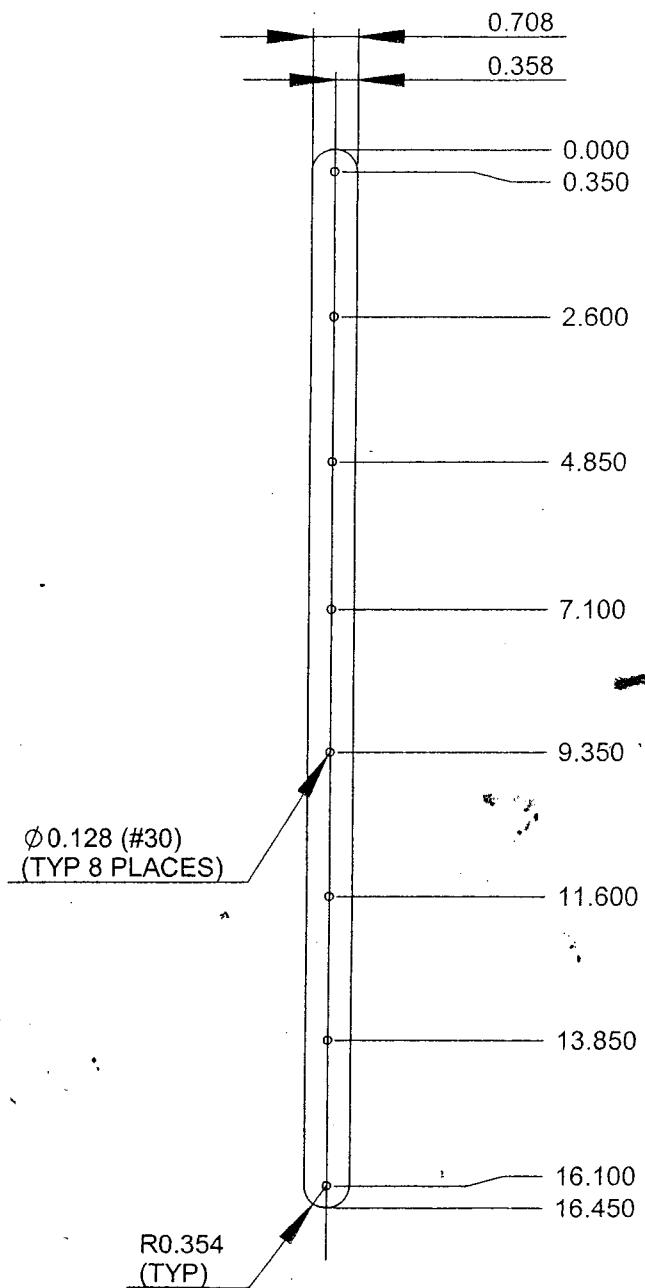
COPY ISSUE

REFERENCE ONLY

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MF</i>	APPROVED <i>MF</i>	DRAWING NO. D3066	REV. A SHEET 1 OF 1
DATE 02.09.11	TITLE SPACER		SCALE 1:3

RELEASED
02.09.2011

A	02.09.11	NEW ISSUE
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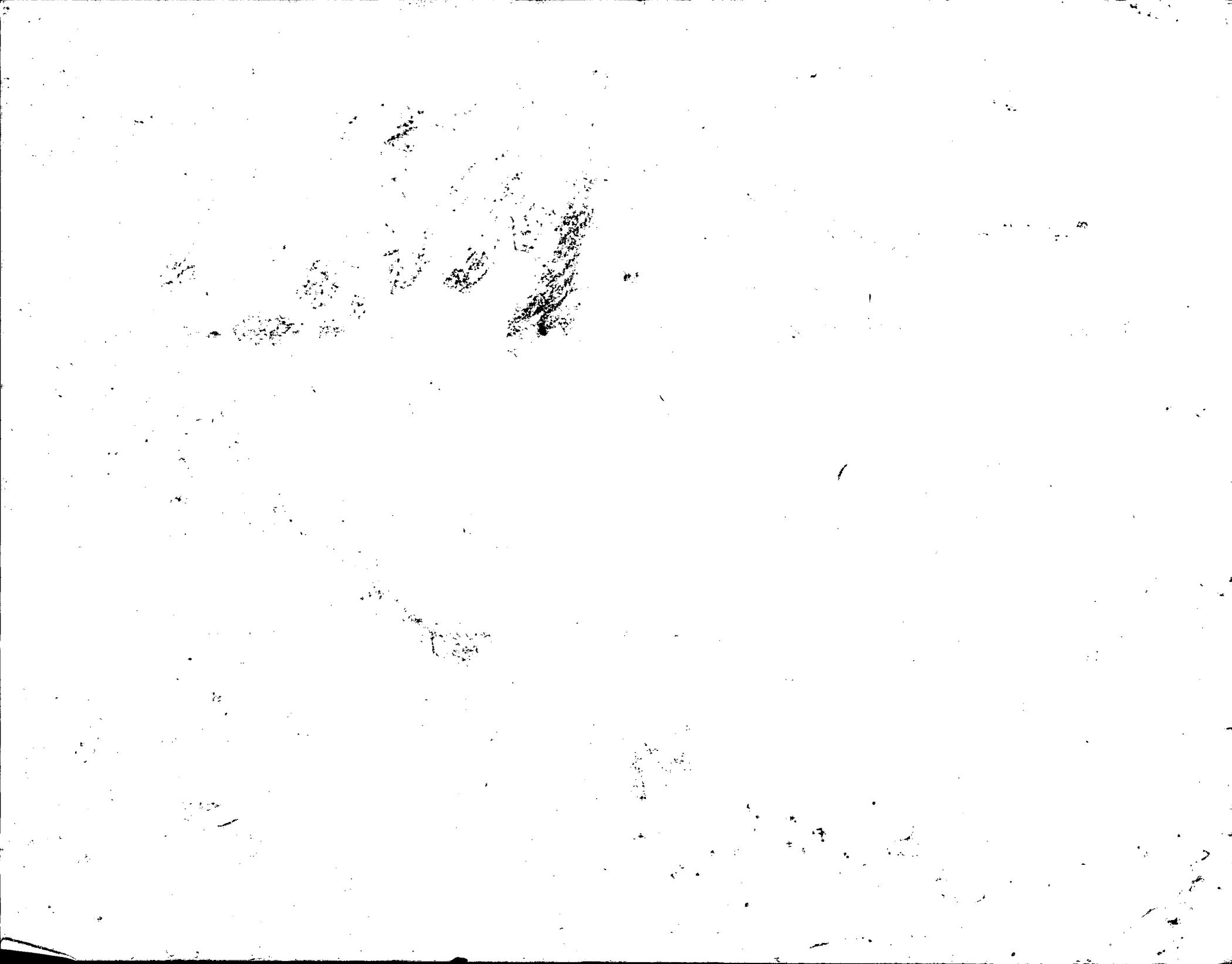


D3066-1 SPACER

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Date: Friday, 11/11/2005 7:53:54 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HI-STEP LEG ASSEMBLY
Job Number	: 24093	Part Number	: D3065041
Estimate Number	: 10385	Drawing Number	: D3065 REV A2
P.O. Number	:	Project Number	:
This Issue	: 11/11/2005	Drawing Revision	: A2
Prsh Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 11/18/2005
Previous Run	:	Qty:	60
Written By	:	Um:	Each
Checked & Approved By	:		
Comment	: Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	24093A	STEP SPACER
	Comment: Sub-Component STEP SPACER	
2.0	24093B	STEP SPACER
	Comment: Sub-Component STEP SPACER	
3.0	24093C	STEP LEG
	Comment: Sub-Component STEP LEG	
4.0	24093D	STEP SPACER
	Comment: Sub-Component STEP SPACER	
5.0	24093E	SPACER
	Comment: Sub-Component SPACER	
6.0	D30651	Step Spacer
7.0	D30653	Step Spacer
8.0	D30655	Step Leg
9.0	D30657	Step Spacer
10.0	MS20470AD44	Rivet, Universal Head
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Assemble as per Dwg D3065 and Identify as D3065-041	

Date: Friday, 11/11/2005 7:53:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 24093

Part Number: D3065041

Job Number:



Seq. #:	Machine Or Operation:	Description :
12.0	QC5	INSPECT WORK TO CURRENT STEP
<p>Comment: INSPECT WORK TO CURRENT STEP</p>		
13.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____</p>		
14.0	DC	DOCUMENT CONTROL
<p>Comment: DOCUMENT CONTROL Inspection Level 21</p>		

Job Completion



Date: Friday, 11/11/2005 7:53:57 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP SPACER		
Job Number	: 24093A			Part Number	: D30651		
Estimate Number	: 10375			Drawing Number	: D3065 REV. A2		
P.O. Number	:			Project Number	:		
This Issue	: 11/11/2005	S.O. No.	:	Drawing Revision	: A2		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 11/18/2005	Qty:	60
Previous Run	:			Um:	Each		
Written By	:			Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
2.0	SHEAR	SHEAR	
Comment: SHEAR Cut blank: 3.600" x 4.500" Grain along 4.500"			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA182 and Dwg D3065 Stack of 15 Identify as D3065-1			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK			
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack			

Date: Friday, 11/11/2005 7:53:57 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 24093A

Part Number: D30651

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Friday, 11/11/2005 7:54:00 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP SPACER		
Job Number	: 24093B			Part Number	: D30653		
Estimate Number	: 10378			Drawing Number	: D3065 REV. A2		
P.O. Number	:			Project Number	:		
This Issue	: 11/11/2005	S.O. No.	:	Drawing Revision	: A2		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 11/18/2005		
Previous Run	:			Qty:	60	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S040	2024-T3 .040 sheet	
2.0	SHEAR	SHEAR	
Comment: SHEAR Cut blank: 6.600" x 4.320" Grain along 4.320"			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA180 and Dwg D3065 Stack of 15 Identify as D3065-3			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK			
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack			

Date: Friday, 11/11/2005 7:54:12 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 24093D

Part Number: D30657

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Friday, 11/11/2005 7:54:19 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 24093E	Part Number	: D30661
Estimate Number	: 10383	Drawing Number	: D3066 REV. A
P.O. Number	:	Project Number	:
This Issue	: 11/11/2005	Type	: SMALL /MED FAB
Prsh Rev.	: NC	Drawing Revision	: A
First Issue	: / /	Material	:
Previous Run	:	Due Date	: 11/18/2005
Written By	:	Qty:	120
Checked & Approved By	:	Um:	Each
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S080	5052-H32 .080 Sheet
2.0	SHEAR	SHEAR
Comment: SHEAR Cut blank: 16.490" x 0.750" -0.000/+0.010"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA280 and Dwg D3065 Stack of 10 Identify as D3066-1		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack		

Date: Friday, 11/11/2005 7:54:19 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 24093E

Part Number: D30661

Job Number:



Seq. #:	Machine Or Operation:	Description :
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		



8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1		

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT CHEMICAL CONVERSION COAT		



10.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		



Comment: DOCUMENT CONTROL
Inspection Level 21
Job Completion



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:52 am

Work Order No	:	0024093	Department Code:		
Project Name	:	D3065-041	Burden Flags	:	NNNNNNN
Project For	:	WK540	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	D3065-041	Invoice Number	:	
Description	:	Step Leg Assembly	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	60	Order Entry No	:	
Amount Done	:	0	OE Value	:	0.00
Start Date	:	08-17-05	Est Margin	:	0.000%
Est Finish Date	:		Actual Margin	:	0.000%
Act Finish Date	:				
Drawings Reqd	:	No			
Ok for Approval	:				
Approval Rec'd	:		\$0 Posted to Finished Goods		

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	86.63	100.00	
Production Cost	:	0.00	1605.49	100.00	0.00
Packaging Hours	:	0.00	0.00	0.00	1605.49
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	25.62	100.00	
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	
Misc.	:	0.00	0.00	0.00	0.00
Burden	:	0.00	0.00	0.00	
Total Cost	:	0.00	1605.49	100.00	
Margin	:	0.000	0.000		
Selling Cost	:	0.00	1605.49		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/ (Loss)	:	0.00	(-1605.49)

Date: Friday, 11/11/2005 7:54:00 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 24093B

Part Number: D30653

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D30653

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Friday, 11/11/2005 7:54:04 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP LEG		
Job Number	: 24093C			Part Number	: D30655		
Estimate Number	: 10382			Drawing Number	: D3065 REV. A2		
P.O. Number	:			Project Number	:		
This Issue	: 11/11/2005	S.O. No.	:	Drawing Revision	: A2		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 11/18/2005		
Previous Run	:			Qty:	120	Um:	Each
Written By	:						
Checked & Approved By	:						
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S080	5052-H32 .080 Sheet	
2.0	SHEAR	SHEAR	
Comment: SHEAR			
Cut blank: 16.61" x 8.51" Grain along 8.51"			
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1			
Machine as per Folio FA179 and Dwg D3065			
Stack of 10			
Identify as D3065-5			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK			
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1			
Deburr Stack			

Date: Friday, 11/11/2005 7:54:04 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 24093C

Part Number: D30655

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Date: Friday, 11/11/2005 7:54:11 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 24093D		
Estimate Number	: 10380		
P.O. Number	:	Part Number	: D30657
This Issue	: 11/11/2005	Drawing Number	: D3065 REV. A2
Prsh Rev.	: NC	Project Number	:
First Issue	: / /	Drawing Revision	: A2
Previous Run	:	Material	:
Written By	:	Due Date	: 11/18/2005
Checked & Approved By	:	Qty:	60
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
2.0	SHEAR	SHEAR
Comment: SHEAR Cut blank: 4.580" x 4.500" Grain along 4.500"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA181 and Dwg D3065 Stack of 15 Identify as D3065-7		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack		